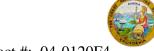
## **DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

## WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-024493 Address: 333 Burma Road **Date Inspected:** 14-Jun-2011

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name: CWI Present:** Yes No An Qing Xiang **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No **Delayed / Cancelled:** Yes No N/A

34-0006 **Bridge No: Component: OBG** Components

### **Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector, Anand Upadhye was present during the times noted above for observations relative to the work being performed.

**NDT** 

**BAY 14** 

This QA inspector witnessed and performed approximately 15 % Magnetic Particle Testing (MT) of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

SA3034-017-001, 002, 010, 011.

SA3034-016-001, 002, 010, 011.

SA3034-015-001, 002, 010, 011.

SA3034-014-001, 002, 010, 011.

SA3034-013-001, 002, 010, 011.

SA3034-012-001, 002, 010, 011.

# WELDING INSPECTION REPORT

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SA3034-011-001, 002, 010, 011.

SA3034-010-001, 002, 010, 011.

SA3034-009-001, 002, 010, 011.

SA3034-008-001, 002, 010, 011.

SA3034-007-001, 002, 010, 011.

SA3034-006-001, 002, 010, 011.

SA3034-005-001, 002, 010, 011.

SA3034-002-004, 005, 013, 014.

SA3034-001-004, 005, 013, 014.

SA3034-004-001, 002, 010, 011.

SA3034-003-001, 002, 010, 011.

#### WELDING

This QA Inspector observed the following work in progress:

Outside Yard – OBG Trial Assembly

This QA Inspector observed ZPMC qualified welding personnel identified as 066361 perform repair welding by Shielded Metal Arc Welding (SMAW), on Deck plate to Edge plate weld of OBG Segment 14W. Weld joint is identified as SEG3020-021. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-345-SMAW-4G (4F)-FCM-Repair-1, which is used as per Critical welding repair report B-CWR3031.

This QA Inspector observed ZPMC qualified welding personnel identified as 037779 perform welding by Shielded Metal Arc Welding (SMAW), on Deck plate DP3168A to Sub Assembly part SA3412A weld of OBG Segment 14W. Weld joint is identified as SEG3020D-055. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2212-Tc U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 037779 perform welding by Shielded Metal Arc Welding (SMAW), on Deck panel diaphragm to Sub Assembly part SA3412A weld of OBG Segment 14W. Weld joint is identified as SEG3020D-056. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general

# WELDING INSPECTION REPORT

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compliance with WPS-B-P-2213-Tc U4b-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 037779 perform welding by Shielded Metal Arc Welding (SMAW), on Sub Assembly part SA3412A to Sub Assembly part SA3416A weld of OBG Segment 14W. Weld joint is identified as SEG3020D-057. ZPMC Quality Control (QC) Inspector identified as Zhu Lin was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2211-Tc U4b-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

## **Summary of Conversations:**

No significant conversations were reported on this date.

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, phone: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Upadhye, Anand	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer